

23. (New) An insulated freight container having a pair of top rails each forming a junction between a side wall and a roof panel of the container, wherein each top rail comprises a first portion for attachment to the respective side wall, an angled second portion which is angled at a first obtuse angle to the first portion and angled inward of the container and a third portion attached to the roof and angled at a second obtuse angle to the angled portion so that the third portion is substantially perpendicular to the first portion, the freight container being made by the method comprising:

providing an outer and inner skin of a floor panel,
locating the inner skin of the floor panel parallel to and spaced from the outer skin by foam spacing stanchions,
injecting foam between the inner and outer skins,
providing outer and inner skins of each side wall, locating the inner skins parallel to the respective outer skins and spaced from them by foam spacing stanchions, inserting foam between the inner and outer skins,
fixing an edge of the side walls to the floor and filling with foam joints between the floor panel and the side walls,
attaching the first portions of the top rails to each side wall,
riveting said top rails to the outer skins of the side walls respectively,
fixing an inner skin of the roof panel to the inner skins of the side walls respectively,
welding an outer skin of the roof panel to the third portions of the top rails, and filling the space between the inner and outer skins of the roof panel